



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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RBEA62309
Job Sheet 170531



002046

Part No: RBEA62309

Job Qty: 1 ea

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBEA62309 rev.12 IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea		2/1/18			DAR001-VU		
110	Small Fab	1 pcs		2/2/18	0.00	1.00	Small Fab-9		
120	QC	1 pcs		2/2/18	0.00	0.00	QC5		
130	Packaging	1 pcs		2/2/18	0.00	0.00	Packaging3-2		
140	QC21-FG	1 Ea		2/2/18	0.00	0.00	QC21		DAS APR 02 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case 7- See note 1 for hoses

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Start up Operation	97524A032	4	259	0	0
	APP-1700-E	1	0	0	0
	RB41011	1	955	0	0
	5048091 RBE-350DAMPER 141	1	0	0	0
	50510 27 RBE-350HYD 141	1	0	0	0
	5053654 RBE-350INCLINOMETER 100	1	0	0	0
	RBE-350TDRS QC 5052768	1	2	0	0
	5045008 RBE-350TEMP GA	1	0	0	0
	5049953 RBE350A93-3200-20 141	1	0	0	0
	5033140 RBE350A93-3205-00E 134	1	0	0	0
	5033138 RBE350A93-3205-00T 134	1	0	0	0
	5048052 RBE350A93-3300-20	1	0	0	0
	RBE350A93-3302-02	1	0	0	0
	5054097 RBE350A93-3303-02	1	0	0	0
	RBE350A93-3305-20	1	0	0	0
	RBE350A93-3307-00	1	0	0	0
	5054650 RBE350A93-3312-03	1	0	0	0
	RBE350A93-3316-20	1	0	0	0
	5045036 RBE350A93-3317-20 141	1	0	0	0
	RBE350A93-3400-00	1	0	0	0
	5052541 RBE350A93-3500-00 141	1	0	0	0
	5045019 RBE350A93-3501-20 141	1	0	0	0
	5050002 RBE350A94-2704-00	1	0	0	0
	RBE350A94-2706-00	1	0	0	0
	5053331 RBE350A94-2708-01	1	0	0	0
	RBE350A94-3301-00 141	1	0	0	0
	RBE350A94-3700-A 134	1	0	0	0

	RBE350A94-3700-C 141	1	0	0	0
5039622	RBE350A94-3701-00 134	1	0	0	0
5038463	RBE350A94-5201-20 141	1	0	0	0
	RBE703A94-1130-01	1	0	0	0
P	RBE703A95-0505-00	1	0	0	0
5046436	RBE703A95-0508-00 72	1	2	0	0
P	RBE703A95-0520-01 141	1	0	0	0
	RBE703A95-0520-01-11	1	0	0	0
	RBE703A95-0520-01-13	1	0	0	0
	RBE703A95-0520-01-15	1	0	0	0
5038222	RBEA62309-65 135	1	0	0	0
	RBEA62309-81 71	1	0	0	0
	RBEA62309-83 71	1	0	0	0
	RBEA62310	1	0	0	0
5043858	RBT18025-13 144	1	0	0	0
5045544	RBW109-3101-58-1-1 102	1	0	0	0
5046740	RBW109-3101-58-2-1 102	1	0	0	0

Part Specifications

Specifications could not be found.

Plex 1/17/18 8:56 AM Dart.lajeunesse.marie



Container No: S056912



Part: RBEA62309

Job No: 170531

Serial No/Batch: S056912

Revision: 12

Inspector:

Dart Aerospace Ltd.
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Date: 03/29/18

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170531
180-12

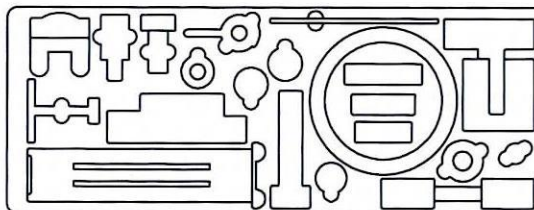
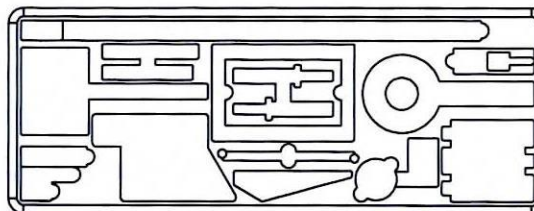
7 FT. HOSES MUST COUPLE IN CUTOUT. MIN TRIM ACCEPTABLE.

		TITLE	
		AS350-355 FIELD MAINTENANCE KIT	
OWD NO.		REV 12	
MATL PART FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/16 .XX ± .003 ANGLES ± 1° .X ± .1 SURFACES ± 1/32	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT		1. BREAK ALL SHARP EDGES .015 ± .45° DR .01SR 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. SEE DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL AS350/355	
SCALE	1:8	DATE	9/20/2016
		SHEET 1 OF 8	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
11	16-0149	ADDED RBW109-3101-58-1 & RBW109-3101-58-2 TO BOM. -45 RBE-RDGS-15 REPLACED W/ RBT18025-13.	9/21/2016	RJC	JAG
12	17-0013	CHD B/O INFO WAS RBE703A95-0250-01 IS RBE703A95-0250-01 -1, -11, -13, -15, WAS RBW109-3101-58-1 IS RBW109-3101-58-1-1, WAS RBW109-3101-58-2 IS RBW109-3101-58-2-1; CHD DESCRIPTION WAS ENGINE & HYDRAULIC DRAIN TUBE IS ENGINE & HYDRAULIC; -77 CHD QTY WAS 1 IS 4.	1/24/2017	SM	JAG

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			1		DAMPER SPANNER WRENCH		RBE-350DAMPER	1
			1		HYD. ACCUMULATOR FITTING GAUGE		RBE-350HYD	1
			1		1/8 DRIVESHAFT BEARING RUNOUT GAUGE		RBE-350TRDS	1
			1		MGB/ROTOR BRAKE RETAINING NUT WRENCH		RBE350A93-3200-20	1
			1		1/8 G/B INPUT FLANGE HOLDING WRENCH		RBE350A93-3205-00T	1
			1		ENGINE G/B INPUT FLANGE HOLDING WRENCH		RBE350A93-3205-00E	1
			1		1/8 HUB SOCKET		RBE350A93-3300-20	1
			1		1/8 HUB LOCK WRENCH		RBE350A93-3302-02	1
			1		1/8 BODY EXTRACTOR TOOL		RBE350A93-3303-02	1
			1		TAIL GEARBOX WRENCH		RBE350A93-3305-20	1
			1		TAIL GEARBOX SEAL EXTRACTOR		RBE350A93-3307-00	1
			1		1/8 HUB BUSHING REPLACEMENT TOOL		RBE350A93-3312-03	1
			1		ROTATING STAR REPLACEMENT WRENCH		RBE350A93-3316-20	1
			1		TAIL ROTOR HUB INSERT TOOL		RBE350A93-3317-20	1
			1		DRIVE SHAFT THIMBLE		RBE350A93-3400-00	1
			1		BEARING EXTRACTOR		RBE350A93-3500-00	1
			1		EXTRACTION TOOL HYD. PUMP PULLEY BEARING		RBE350A93-3501-20	1
			1		M/R BLADE TRIM TAB TOOLS		RBE703A94-1130-01	1
			1		JAMMING TOOL, PEDALS		RBE350A94-2704-00	1
			1		RIGGING PIN SET		RBE350A94-2706-00	1
			1		1/8 BLADE LOCK FIXTURE		RBE350A94-2708-01	1
			1		1/8 ACCELERATOR SUPPORT		RBE350A94-3301-00	1
			1		SWASHPLATE IMMOBILIZING TOOL LONG BRACE		RBE350A94-3700-A	1
			1		SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE		RBE350A94-3700-C	1
			1		M/R RIGGING TOOL		RBE350A94-3701-00	1
			1		CARTRIDGE, DUMMY, FUEL		RBE350A94-5201-20	1
			1		ENGINE & HYDRAULIC		RBE703A95-0520-01 -1, -11, -13, -15	1
			1		IGB DRAIN TUBE		RBE703A95-0505-00	1
			1		MGB DRAIN TUBE		RBE703A95-0506-00	1
			1		LINEAR SCALE		RBT18025-13	1
			1		AS350/355 ENGINE STRUT		RBEA62310	1
			1		HAMMER, STEEL		RBW109-3101-58-1-1	1
			1		HAMMER, ALUMINUM		RBW109-3101-58-2-1	1
			1		INCLINOMETER		RBE-350INCLINOMETER	1
			1		TEMPERATURE PROBE		RBE-350TEMP	1
			-65	1	LAMINATED LOCATION CARD	LAMINATED CARD		6
	B/O		-67	1	LANYARD	COATED STEEL	Ø1/16 X 12 CARR LANE #CL-2-C	N/S
	B/O		-69	1	GROMMET	NICKEL-PLATED BRASS	SIZE 00, Ø.42 OD (MCMMASTER-CARR #84625K31)	N/S
	B/O		-71	1	EYELET	COATED COPPER	SIZE 2 (CARR-LANE #CL-194-TERA-2)	N/S
	B/O		-73	4	PIVET	ALUMINUM	Ø3/16 X 3/8 - 1/2 (MCMMASTER-CARR #97526A421)	N/S
	B/O		-75	1	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMMASTER-CARR #3896131)	N/S
	B/O		-77	4	ELASTIC RETAINER W/HOOKS	BUNGEE CORD	Ø1/4 X 10in.	1
	B/O		-79	1	HARD CASE	PLASTIC	PELICAN #APP-1700-E	N/S
	B/O		-81	1	TOP SHELF CUSHION	ETHAFOAM 220, BLACK	1.81 X 13-5/8 X 35-5/8 (CASE SOLUTIONS)	3 & 4
	B/O		-82	1	TOP CUSHION STIFFENER	COROPLAST, BLACK	6mm X 13-5/8 X 35-5/8 (CASE SOLUTIONS)	5
	B/O		-83	1	BOTTOM SHELF CUSHION	ETHAFOAM 220, BLACK	3-1/4 X 13-5/8 X 35-5/8 (CASE SOLUTIONS)	6 & 7
	B/O		-87	1	REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	1
	B/O		-89	1	CABLE TIES	NYLON	(MCMMASTER-CARR #7189E31)	1
	B/O		-91	1	VIAL FOR FLANGE WRENCH BOLTS	POLYPROPYLENE	Ø2.03 O.D. X 1.58in. (MCMMASTER-CARR #52741761)	1
	B/O			1	DART PLACARD	ALUMINUM	RB41011	N/S



DART AEROSPACE	
TITLE AS350-355 FIELD MAINTENANCE KIT	
DWG NO. RBEA62309	REV 12
MAT'L _____ REKT _____ USAT _____ FINISH _____ SPEC _____	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES ± 125 1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:1	DATE 9/20/2016
SHEET 2 OF 8	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			